

Split

Ship Jan 6th, 2017

Work Order ID 154337-2

154337

Thursday, December 08, 2016 4:03:46 PM

Page 1

Item ID: D4039-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Bracket Assembly

Start Date: 12/12/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/3/2017 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4039	C

100 0.00

13 Rick kit

DAS
6
9-89

JAN 05 2017

100

Small Fab Memo 0.00
Small Fab 1- Assemble lanyard to bracket as per dwg

L FF JAN 17 2017

110 QC5- Inspect part completeness to step on W/O 0.00

110

QC Memo 0.00
Quality Control

DAS
38
9-89

JAN 19 2017

120 Identify as per dwg & Stock Location: SM11 0.00

120

Packaging Memo 0.00
Packaging

DAS
6
9-89

JAN 20 2017

Work Order ID 154337

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154337

Page 2

Item ID: D4039-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Bracket Assembly
Start Date: 12/12/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 1/3/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

DA.
21
9-89

JAN 24 2017

JAN 20 2017

Picklist Print

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Page 1

Work Order ID: 154337

154337

Parent Item: D4039-043

D4039-043

Parent Item Name: Aft Bracket Assembly

Start Date: 12/12/2016

Required Date: 1/3/2017

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP RevA: new issue DD 09.12.15 verified by:EC
B:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD

IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4039-3 *D4039-3* Aft Bracket		Manufactured	No			100	Each	0.0000	1	34 154/338	DAS 6 9-89	JAN 05 2017	
D2690-6 *D2690-6* Lanyard		Manufactured	No			100	Each	11.0000	1	34	DAS 6 9-89	JAN 05 2017	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST009	151983			11					
MS17984-C416 *MS17984-C416* Quick Release Pin		Purchased	No				Each	4.0000		152878 34	DAS 6 9-89	JAN 05 2017	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				over005	m136089			4					
MS27039-1-11 *MS27039-1-11* Screw		Purchased	No			100	Each	125.0000	1	4136579 ① FF 152878 34	DAS 6 9-89	JAN 17 2017	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA	9662			8					
				ST280	m134738			117					
					m135978			17					
								100					

Picklist Print

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Page 2

Work Order ID: 154337

Parent Item: D4039-043

Parent Item Name: Aft Bracket Assembly

154.337

D4039-043

Start Date: 12/12/2016

Required Date: 1/3/2017

Start Qty: 3.00

Required Qty: 3.00

MS21042L3

Purchased

No

100

Each

1,745.000

1

34

MS21042L3

Nut

**

DAS

6

9-89

JAN 05 2017

Location

Loc Qty

Loc Code

CCK007

600

M136192

600

FP001

100

m135945

100

GA

176

m134360

108

m135135

68

ST303

869

m135945

269

M136044

600

4

9/12

NAS1149D0363J

Purchased

No

100

Each

1,617.000

3

NAS1149D0363J

Washer

**

DAS

6

9-89

JAN 05 2017

Location

Loc Qty

Loc Code

GA

332

m134055

332

ST260a

1000

m136318

1000

ST263

285

m135864

285

12

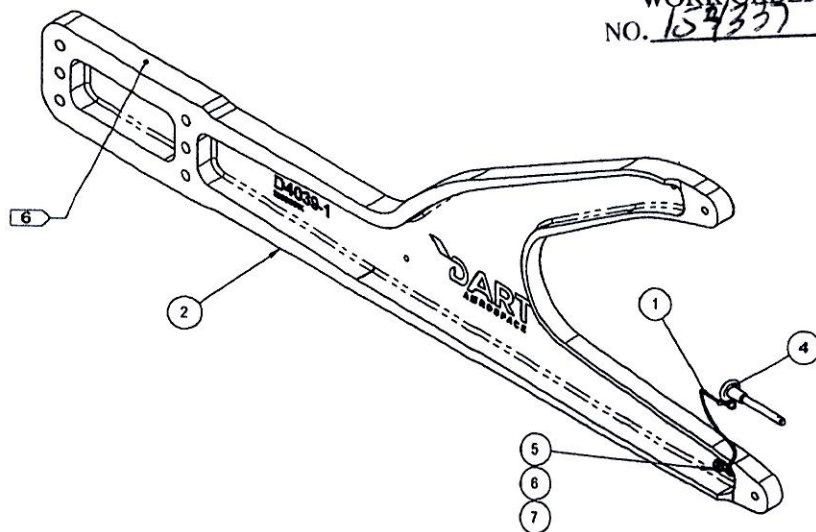
Thursday, December 08, 2016 4:03:52 PM

Shop Packet Print

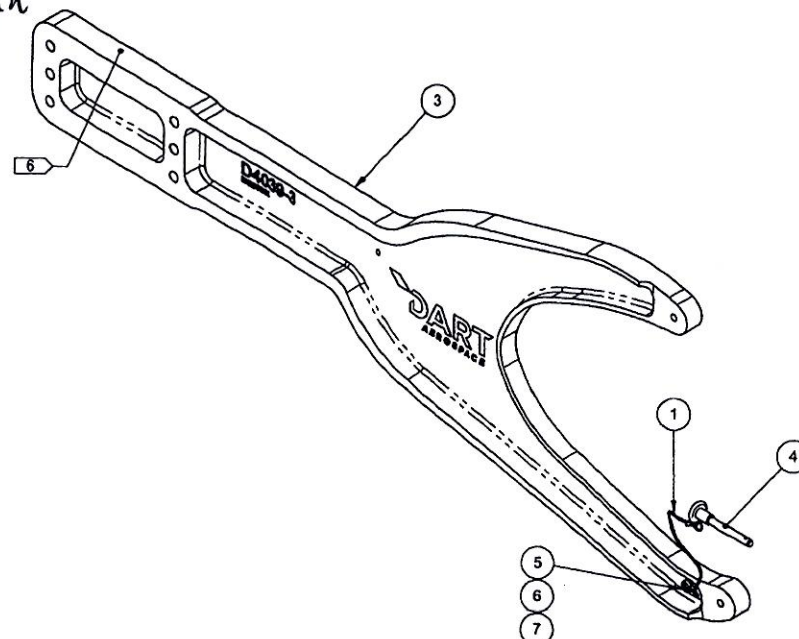
Page 2

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4039-041	FWD BRACKET ASSEMBLY
		X	D4039-043	AFT BRACKET ASSEMBLY
1	1	1	D2690-6	LANYARD
2	1		D4039-1	FWD BRACKET
3		1	D4039-3	AFT BRACKET
4	1	1	MS17984-C416	PIN, QUICK RELEASE
5	1	1	MS27039-1-11	SCREW, PAN-HEAD
6	1	1	MS21042L3	NUT, SELF-LOCKING
7	3	3	NAS1149D0363J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154337



D4039-041 FWD BRACKET ASSEMBLY



D4039-043 AFT BRACKET ASSEMBLY

RELEASED

2016 NOV 02
EOL 14-513 4P

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: N/A

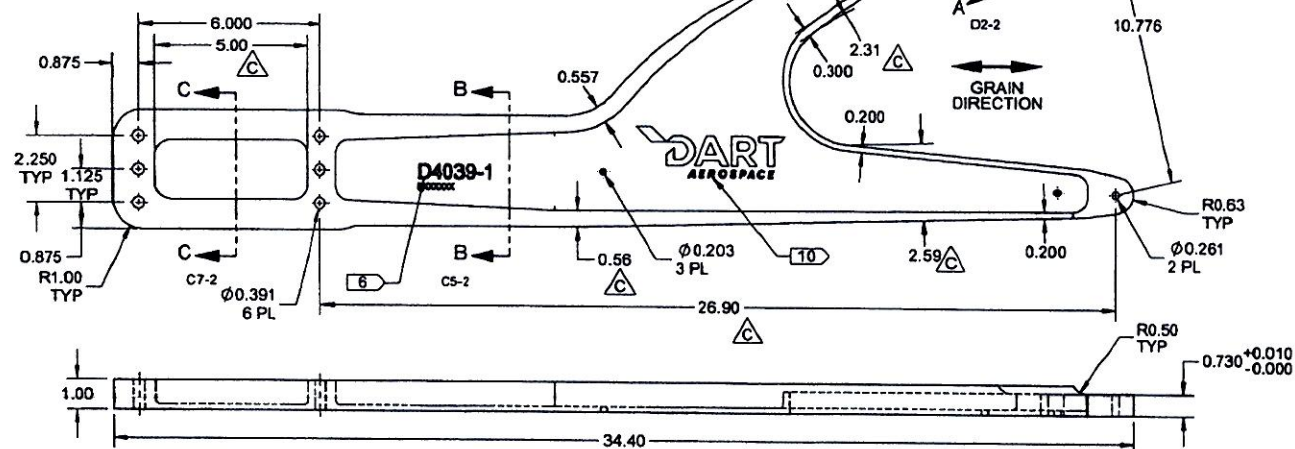
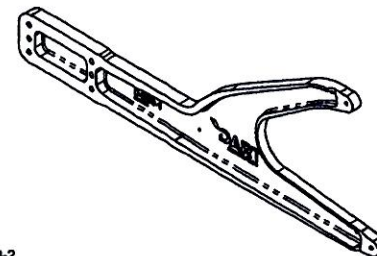
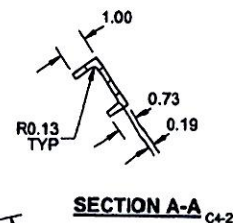
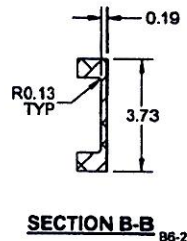
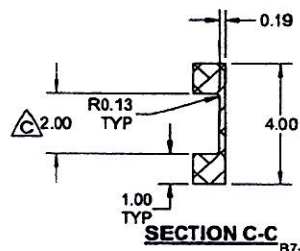
C	REVISE DESIGN OF -1 AND -3 BRACKETS: ZN C4-2, B4-2, C4-3, B4-3. REVISE NOTES 7 AND 8; A8-2, A8-3, B5-1	VS	15.11.05
B	REVISE HOLE SIZE ON D4039-3 FROM 0.191 TO 0.203, ZN B6-3	HS	10.04.28
A	NEW ISSUE	HS	09.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	VS		
DRAWN	VS		
CHECKED	RF		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	15.11.05		

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4039
TITLE
BRACKET
REV. C
SHEET 1 OF 3
SCALE
NTS

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D4039-1 FWD BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4026 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND B/N IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010 PER QSI 044 6.3
- 7) WEIGHT: 6.60 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-1.SLDPRT" AT REV. C
- 9) UNDEFINED FEATURES CONTROLLED BY SOLIDWORKS PART "D4039-1.SLDPRT" AT REV. C
- 10) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

RELEASED

2016 NOV 02

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4039	SHEET 2 OF 3
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	BRACKET	NTS
DATE		15.11.05	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

